



Dart Aerospace Ltd.
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D350,636-011
Job Sheet 176614



Part No: D350-636-011

Job Qty: 1 ea

Part Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/26/18

Job Tracking No:

Due Date: 5/21/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D2750-041 REV G SHEETS 1,2,4,8 IPP Rev:I 02.09.25 IPP Rev:J 06-03-23 As per Rev D IPP Rev:K 06-07.13
As per dsi9343 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Ver:EC IPP Rev:M 08-04-22 DD
verified:EC IPP Rev:N 08-09-23 revF DD verified:ec IPP Rev:O 09-02-06 per PAR09-010 DD ver:EC IPP
Rev:P 10.06.22 revise seq110 DD ver:EC IPP Rev:Q 10.10.01 as per IIN revH DDver:EC IPP REV:R
13.08.27 PER ECN13-594 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		5/21/18	0.00	0.00	Start Up Skid tubes-1		
110	Skid tubes	1 pcs		5/21/18	0.00	4.55	Skid tubes-4		
120	QC	1 pcs		5/21/18	0.00	0.00	QC10		38 DAS
130	QC	1 pcs		5/21/18	0.00	0.00	QC5		9-89 38
140	HandFinish	1 pcs		5/21/18	0.00	0.93	HandFinish1		SA 18-06-04
150	QC	1 pcs		5/21/18	0.00	0.00	QC7-2		SE
160	Skid tubes	1 pcs		5/21/18	0.00	4.55	Skid tubes-4		DD 18-06-04 14 Fg072
170	QC	1 pcs		5/21/18	0.00	0.00	QC10		38 DAS
180	QC	1 pcs		5/21/18	0.00	0.00	QC5		9-89 38
190	HandFinish	1 pcs		5/21/18	0.00	0.93	HandFinish2		SA 18-06-05
200	SprayPaint	1 pcs		5/21/18	0.00	0.91	Spray Paint		JMD 17/06/2018
205	Outsource	1 pcs		5/21/18			ATE003-VC		
210	QC	1 pcs		5/21/18	0.00	0.00	QC14		
230	HandFinish	1 pcs		5/21/18	0.00	0.93	HandFinish4		DAS
240	QC	1 pcs		5/21/18	0.00	0.00	QC5		38
250	Packaging	1 pcs		5/21/18	0.00	0.00	Packaging1-3		JO JUN 29 2018
260	QC	1 pcs		5/21/18	0.00	0.00	QC4		38 DAS
265	DC	1 pcs		5/21/18	0.00	0.00	DC		38 28
270	Packaging	1 pcs		5/21/18	0.00	0.00	Packaging3-1		21 9-89
280	QC21-FG	1 Ea		5/21/18	0.00	0.00	QC21		9-89 JUN 29 2018

Part Op 110 - 1- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg
Descriptions: D2750-1 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill
then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. ***ENSURE PROPER
POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE*** Drill pilot holes as per Dwg D2750
sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for 2nd side only DT8863B for first side (detail B) 4-
Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY
AND RECORD FWD BEND ANGLE. 5-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".
6-Open up holes of Detail A to 0.297" (total of 2 holes per side) 7-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill
grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: 138839 8-Grind welds flush as per Dwg
D2750
160 - 1-Open up holes using hole saw of Detail C and ground handling to 0.625" (total of 8 holes per side) as per dwg
D2750. 2-Open up holes using hole saw of Detail B to 0.750" (total of 4 holes per side) as per dwg D2750. 3- Open float

DQA: _____ Date: _____
QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐



Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Scrap ☐	Skid-tube Machining ☐	Cross tube Small Fab ☐	Water Jet ☐	Engineering Quality ☐
Suspected Unapp		Use ☐				

Date: _____ Step #: _____

Description Work Order Deviation

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Date: 05/31/18



Container No: S076930
Part: D350-636-011
Job No: 176614
Serial No/Batch: S076930
Revision: _____
Inspector: _____
Exp Date: 05/31/2018
Instructions: _____

Root Cause			
Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
	☐	Poor Information	☐
	☐	Rushing	☐
	☐	Improvement	☐
	☐	Measurement	☐
Past Expiry Date	☐		
Misidentified	☐		
OTHER: ☐			
		Pressure/Forced Bending	☐
		Centre Not Concentric	☐
		Cracks	☐
		Crimp/Kink/Ripple/Wave	☐
		Cuffs	☐
		Crushing	☐
		Heat Treat	☐
		Wave/Twist in Tube	☐
		Marks/Chatter	☐
		BOM/Route	☐
		Broken/Damage/Defect	☐
		Inspection Incomplete/Unqualified	☐
		Contamination	☐
		Countersink	☐
		Cut Too Short	☐
		Instructions Incomplete/Unclear	☐
		Drill Holes	☐
		Grain	☐
		Weld	☐
		Wrong Stock Pulled	☐
		Out of Sequence	☐
		Off-set	☐
		Mislabeled	☐
		Fit/Function	☐
		Misaligned/off center	☐
		Over/Under tolerance	☐
		Part Incorrect	☐
		Part Lost/Missing	☐
		Part Moved	☐
		Drawing	☐
		Finish	☐
		Misread	☐
		Turning Sequence	☐

hole using un-bit to 0.500" (4 per side) 4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750 (welding instructions on sheet 8) 5-Debur and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7-Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: 135787 exp. date: 2018/05/12 ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 8) A/R Aluminum Rod batch: 138863 9- At section AJ-AJ drill out x-bolt spacer to 0.404" 10-Grind welds flush as per Dwg D2750 11-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750 12-Debur holes, ensure tube is free of all scratches before sending to paint.

180 - ***VERIFY C'BOARD IS GOOD***

190 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 138747 2-

PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 138863

210 - Inspect for foreign object per QSI 024

230 - 1- Install inserts as per Dwg D2750 2-Inspect for Foreign Objects 3- Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: M129.788 EXP DATE: 1812 4-

Assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: _____ 5- Coat all exposed fasteners with "LPS Procyon" batch: M133690

260 - *****ensure antiseize is on AN8C21A bolts*****

265 - record fwd angle: _____ Photocopy blue file and type labels per PPP D350-636-011 CHG 007

270 - Package as per PPP D350-636-011 Location : FG072

003941

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-LH	Extrusion Bent LH	1 Ea (1 ea)	90-Start up Operation	5073819
D2744	Cap	1 Ea (1 ea)	90-Start up Operation	5063692
D2739	350 I-Beam	1 Ea (1 ea)	160-Skidtubes	5044038
D2743	Crossbolt Spacer	8 Ea (8 ea)	160-Skidtubes	5051803
D3490-1	Cross Bolt Spacer	4 Ea (4 ea)	160-Skidtubes	5065863
D3490-3	Cross Bolt Spacer	4 Ea (4 ea)	160-Skidtubes	5066254
AN3C5A	Bolt	34 Ea (34 ea)	230-HandFinish	5057153
AN3C6A	Bolt	4 Ea (4 ea)	230-HandFinish	5076000
AN6C44A	Bolt	4 Ea (4 ea)	230-HandFinish	5006333-1
AN8C35A	Bolt	1 Ea (1 ea)	230-HandFinish	FM137203
D2745	Bushing	8 Ea (8 ea)	230-HandFinish	5058257
D3488-041	Blade Fitting LH	1 Ea (1 ea)	230-HandFinish	5070858
D3492-1	Plug	8 Ea (8 ea)	230-HandFinish	5077552
D3492-3	Plug	8 Ea (8 ea)	230-HandFinish	5072782
D3535-25	Wearplate Center	1 Ea (1 ea)	230-HandFinish	5060747
D3536-25	Gasket Center	1 Ea (1 ea)	230-HandFinish	5059811
D3537-1	Wearpad	3 Ea (3 ea)	230-HandFinish	5070788
D3631-1	Washer	8 Ea (8 ea)	230-HandFinish	5058407
D3791-1	Wearpad	1 Ea (1 ea)	230-HandFinish	5059890
D3793-1	Wearplate Fwd	1 Ea (1 ea)	230-HandFinish	5070808
D3793-3	Wearplate Aft	1 Ea (1 ea)	230-HandFinish	5047277
D3794-1	Gasket Fwd	1 Ea (1 ea)	230-HandFinish	5054813
D3794-3	Gasket Aft	1 Ea (1 ea)	230-HandFinish	5046513
MS21043-6	Nut	4 Ea (4 ea)	230-HandFinish	5076009
MS21083C8	Nut	1 Ea (1 ea)	230-HandFinish	5073370
NAS1149C0332R	Washer	38 Ea (38 ea)	230-HandFinish	5056493
NAS1149C0832R	Washer	1 Ea (1 ea)	230-HandFinish	M138409.121
NAS1515H3L	Washer	4 Ea (4 ea)	230-HandFinish	5036714
NAS1611-010	O-Ring	8 Ea (8 ea)	230-HandFinish	5022098
NAS1611-013	O-Ring	8 Ea (8 ea)	230-HandFinish	5034467
ALS4-1032-225	Rivnut	38 Ea (38 ea)	230-HandFinish	5058138
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging	FM137162 5040883
D2741	Replacement Blade	1 Ea (1 ea)	250-Packaging	5067108
D3493-1	Washer	2 Ea (2 ea)	250-Packaging	5062610
D3532-1	Spacer	2 Ea (2 ea)	250-Packaging	5050046
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging	F125625
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2600-3-BENT-LH	1	3	0

160-Skidtubes	D2744	1	87	0
	D2739	1	16	0
	D2743	8	134	0
	D3490-1	4	28	0
230-HandFinish	D3490-3	4	11	0
	ALS4-1032-225	38	5,580	0
	AN3C5A	34	1,993	0
	AN3C6A	4	286	0
	AN6C44A	4	363	0
	AN8C35A	1	52	0
	D2745	8	137	0
	D3488-041	1	5	0
	D3492-1	8	120	0
	D3492-3	8	45	0
	D3535-25	1	27	0
	D3536-25	1	35	0
	D3537-1	3	126	0
	D3631-1	8	955	0
	D3791-1	1	23	0
	D3793-1	1	11	0
	D3793-3	1	19	0
	D3794-1	1	24	0
	D3794-3	1	32	0
	MS21043-6	4	212	0
	MS21083C8	1	137	0
	NAS1149C0332R	38	6,209	0
	NAS1149C0832R	1	73	0
	NAS1515H3L	4	211	0
	NAS1611-010	8	601	0
	NAS1611-013	8	397	0
250-Packaging	AN8C21A	2	107	0
	D2741	1	54	0
	D3493-1	2	34	0
	D3532-1	2	46	0
	MS21083C8	2	137	0
	NAS1149D0863J	2	125	0

Part Specifications

Specifications could not be found.